



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6795614
Job Sheet 199574



Part No: RB6795614

Job Qty: 2 pcs

Part Name: Puller/Pusher Idler Gear Support Shaft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Due Date: 11/11/19

Created By: Chantal Lavoie

Type: SOLD

Description:

Note: DWG RB6795614 Rev 0 IPP Rev. A 19.06.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Purchasing	DAS 2 pcs 13 9-89 PO 413044334 x2	11/11/19		0.00	0.00	Purchasing - 1	DP
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Recelve - B4B	2 pcs	11/11/19		0.00	0.00	Packaging 2 - 1 - B4B	DP
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



Container No: S222572



Part: RB6795614

Job No: 199574

Serial No/Batch: S222572

Revision: 0

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/15/19

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	2 pcs	11/11/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	DAS
					QC 6 - 40	81
					QC 6 - 81	9-89
						OCT 16 2019
130	Packaging 3-1 - Stock - B4B	2 pcs	11/11/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DA
					Packaging 3 - 6 - B4B	21
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - FG	2 pcs	11/11/19	0.00 0.00	QC 21 - FG - 21	DAS
					QC 21 - FG - 70	21
					QC 21 - FG - 53	9-89
						OCT 16 2019

Part Op 100 - Issue P/O to ARROW TECH MACHINE WORKS ; P/O _____ -Manufacture RB6795614 as per DWG. -
 Descriptions: Certificate of Conformity is required
 110 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB6795614P	Puller/Pusher Idler Gear Support Shaft	2 Ea (1 ea)	100-Purchasing	5222564

8/28/2019

[Dart Hawkesbury] Job Sheet - Lavoie, Chantal

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB6795614P	2	0	0
Part Specifications				
Specifications could not be found.				

Plex 8/28/19 10:47 AM Dart.Lavoie.Chantal



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Tel (613) 632-5200

PURCHASE ORDER

POHB044334



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB044334

PO Date: 8/23/19

Due Date: 11/11/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Pynt Terms: Net 30

Freight Terms:

Special Comments: QUOTE # 332

REVISED
10/10

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	199568	RB23003262P			LOCKNUT CRIMPER	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$1,248.45/pcs	\$2,496.90
2	199569	RB23033030P			DRIFT-INSTALLATION COMPRESSOR	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$293.73/pcs	\$587.46
3	199570	RB23033031P			FRONT BEARING HOUSING HOLD FIXTURE	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$427.62/pcs	\$855.24
4	199571	RB23033032P			DRIFT-COMPR.FRONT BEARING OU	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$376.53/pcs	\$753.06
5	199572	RB23033035P			PULLER-COMP FRONT BEARING RING	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$3,230.00/pcs	\$6,460.00
6	199573	RB6795588P			Wrench-Holding, 32/64 Pitch 24 Tooth Spline	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$918.66/Ea	\$1,837.32
7	199574	RB6795614P			Puller/Pusher Idler Gear Support Shaft	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$538.00/Ea	\$1,076.00
8	199575	RB6795974P			Torquemeter Shaft Alignment Tool	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$860.00/Ea	\$1,720.00
9	199576	RB6795984P			Power Turbine Holder Shaft	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$721.00/Ea	\$1,442.00

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PURCHASE ORDER

POHB044334



Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
10	199579	RB6796930P			Accessory Gear Box Install Plate	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$841.00/Ea	\$1,682.00
11	199580	RB6796946P			Install & Removal Accessory Gear Box Bearings Drift	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$353.00/Ea	\$706.00
12	199581	RB6796948P			Drift Install/Removal Accessories Gear Box	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$310.00/Ea	\$620.00
13	199582	RB6796949P			Accessory Gear Box Bearings Installation Drift	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$292.00/Ea	\$584.00
14	199583	RB6796966P			RET. RING, FUEL CTR. DR. PLIER	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$827.00/pcs	\$1,654.00
15	199584	RB6798047P			WRENCH OIL SUMP TURBINE	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$518.78/Ea	\$1,037.56
16	199585	RB6798807P			COMP. LUBE OIL FILTER POPP VAL	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$845.25/pcs	\$1,690.50
17	199586	RB6799518P			PULLER-GAS PRODUCER BALL BEARING LABYRINTH SEAL ASSEMBLY	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$792.00/pcs	\$1,584.00
18	199587	RB6799973P			PULLER SEAL POWER TURBINE BELLOWS TYPE	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$2,291.81/Ea	\$4,583.62
19	199588	RB6872165P			HELICAL DRV GEAR ASSY INTRNL CLRNC GAGE	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$2,058.00/pcs	\$4,116.00
20	199589	RB6872541P			PWR TURB SUPPORT PROTECTIVE CVR	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$380.27/pcs	\$760.54
21	199590	RB6872575P			RIGGING PIN	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$319.00/pcs	\$638.00

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PURCHASE ORDER POHB044334



Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
22	199593	RB6872746P			Puller, Power Train Drive Gear Bearing	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$1,950.00/Ea	\$3,900.00
23	199594	RB6872880P			Compressor Mounting Inserts Checking Fixture	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$1,905.00/Ea	\$3,810.00
24	199595	RB6872927P			RED. GEAR FLANGED STUD WRENCH	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$340.64/pcs	\$681.28
25	199596	RB23006778P			GUIDE SPUR ADAPTER GEAR SHAFT	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$533.00/pcs	\$1,066.00
						XZ		OCT 15 2019					DP
26	199597	RB23033033P			DRIFT GUIDED COMPRESSOR FRONT BEARING RING SEAL	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$858.75/pcs	\$1,717.50
27	199598	RB6795969P			Holder Torquemeter Shaft Support	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$765.86/Ea	\$1,531.72
						XZ		OCT 15 2019					DP
28	199599	RB6796918P			Install Turbine & Exh Colct Support Oil Bellows Seal Dft	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$877.00/Ea	\$1,754.00
						XZ		OCT 15 2019					DP
29	199600	RB6796941P			Seals Replacement, Accessories Gear Box	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$4,053.00/Ea	\$8,106.00
30	199601	RB6796950P			Accessory Gear Box Bearing Puller	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$3,698.00/Ea	\$7,396.00
31	199602	RB6798292P			Wrench Ground Idle Screw Adjusting (Hinged)	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$623.21/pcs	\$1,246.42
						XZ		OCT 15 2019					DP
32	199603	RB6798927P			Compressor Impeller Assembly	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$1,185.00/Ea	\$2,370.00
33	199604	RB6799955P			Fixture-Assembly Turbine	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$2,598.41/Ea	\$5,196.82



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PURCHASE ORDER **POHB044334**



Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
34	199605	RB6872879P			SPOTFACING FIXTURE	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$743.50/pcs	\$1,487.00
35	199606	RB6872881P			COMPR MTG INSERT WRENCH	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$327.00/pcs	\$654.00
36	199608	RB6872882P			Turbine Front Bearing Puller	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$3,399.00/pcs	\$6,798.00
37	199610	RB6886201P			POWER TAKEOFF ROLLER BEARING GUIDE	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$904.00/pcs	\$1,808.00
38	199611	RB6798316P			ADAPTER TURNOVER STAND	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$807.00/Ea	\$1,614.00
												Grand Total:	\$88,020.94

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 8/28/19 11:38 AM Dart.Lavoie.Chantal



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB044334

Dated: 10/11/2019

Our Order / Job No: AWT-HB044334 A7

Order Qty: 2

Part Name: PULLER/PUSHER IDLER GEAR SUPPORT SHAFT

Part Number RB6795614

Lot Size: N/A

Ship Date: 10/11/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB6795614

Rev: 0

Material Size and Type: -2/ 1018 STEEL; -3/ 4140 STEEL

Material Specifications: STEEL: ASTM A108

Heat Treatment: 35-36 RC

Plating/Finish: ZINC PLATE: ASTM B633 TYPE I SC 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 10.09.19

Signed: 

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

DART SUPPLIER DEVIATION REQUEST



A. Supplier Information		B. Part Information	
Date: 7/25/19		Part Number: RB6795614-1 (-1A, -1B)	
Name: ArrowTech Machine Works		Description: Shaft	
Contact: Gabriel Escobar		Revision: 0	
Phone #: 541-780-6938		PO Number: HB043785	
Requestor Title: Production Manager		Quantity of parts affected: 1	
C. Deviation Information			
Deviation Request is:			
Product Related	☒	1st Time	☒
Process Related	☐	Repeat	☐
		Permenant	☒
		Temporary	☐
		Duration _____	
Current Requirement	Requested Deviation	Reason for Deviation	
(-1A) Hex Nut welded on (-1B) shaft.	Alternate Method of Mfg. McMaster#91247A611	Product improvement	

DART SUPPLIER DEVIATION REQUEST



D. Correction Action Taken		E. Preventive Action	
F. DART Approvals	Signature	Date	Approve / Disapprove
Purchasing			
Engineering	<i>M. Lee</i>	July 26, 2019	Approve
Manufacturing			
Quality			
Other			
G. Disposition (Completed by DART)			
Drawing Change Required?	Yes ☐	No ☒	If Yes ECN / URF Number:
Supplier Corrective Action Request Required?	Yes ☐	No ☐	If Yes SCAR Number:
Comments:			
No change to fit, form or function			

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: <u>199574</u>		DISPOSITION		DEPARTMENT/PROCESS				Engineering		
Part No. <u>286795-614</u>		☐ Rework ☐ Scrap ☒ Use-as-is		☐ Cross tube ☐ Small Fab ☐ Finishing				☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging		☐ Water Jet ☒ Supplier ☐ Quality
Date: <u>Oct 16 2019</u>		Sequence #: <u>QC. 6</u>		QTY Affected: <u>2062</u>		MRR (QSD42) DA: <u>51</u> <u>19/10/16</u> <u>9-8:</u>				
Description Work Order Deviation		Disposition								
Length of shaft is 7 3/4", should be 7"										
Completed By		Lead hand / Supervisor								
QC / QA Coordinator										

Root Cause		FAULT CATEGORY																	
Operator	☐	Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Outside Tolerance	☒	Drawing	☐	Finish	☐	Part Lost/Missing	☐	Misread	☐
Manufacturing Process	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set/Set-up	☐						
Equip/Tooling	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Weld	☐										
Handling/Preservation	☐	Cracks	☐	Broken/Damage/Defect	☐	Wrong Stock Pulled	☐	Out of Sequence	☐										
Material	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Drill Holes	☐	Fit/Function	☐										
Product Improvement	☐	Marks/Chatter	☐		☐														
Process Improvement	☐	Mislabeled	☐		☐														
Human Factors	☒	Other/Details:																	